Work Orde Tuesday, June 15											Page 1	
Item ID: Revision ID:	D3909-5		4	Accept					Setup	Start		
Item Name:	Eyebolt Stud									Stop		
Start Date: Required Date:	6/15/2010 6/21/2010	Start Qty: 6.00 Req'd Qty: 6.00			Cust Item Customer						1,20,1,01,0	·•··
Reference:			· · · · · · · · · · · · · · · · · · ·		,						1	
Approvals:	Process Pla	n:	Date: 10-6-15	Tooling:		Date:		•	Run	Start		
	QC:		Date:	SPC (Y/N):	I	Date:				Stop		
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3909	В										!	
Doosan		M		0.00				1880 - 440 -				
Doosan Lathe		Memo turn as per DWG REV FOLIO RE			10/06/27		(6				

0.00

DEBURR

Memo

QC2- Inspect parts off machine FAI/FAIB

110

Quality Control

Dart Ae	rospace Lt	a						
W/O:			WC	RK ORDER CHANG	GES		**	
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	Reso	lution:	Disposition	1:	QA: N/C C	losed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)		
DATE	STEP	Description of NC Section A	Initial	Corrective Action Sec Action Description	Sign	Verification	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	Approva
		Section A	Chief Eng	Chief Eng	Date		Chief Eng	QC Inspecto
NOTE: D	ate & initial all	enties		and the second s				

H:\fFOn MS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 59855

Tuesday, June 15, 2010 8:33:35 AM



Page 2

Item ID:

D3909-5

Accept

Setup Start

Revision ID:

Item Name: **Start Date:**

Eyebolt Stud

6/15/2010

Start Oty: 6.00

Required Date: 6/21/2010 Req'd Oty: 6.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date:

Tooling:

Date:

Start

Stop

QC: _____ Date:____

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

120

QC

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

0.00

Tool # Plan

Code

Accept Qty

Reject Qty

Run

Reject Insp. Number Stamp

150

Packaging Packaging

Memo

Identify as per dwg & Stock Location: 093

0.00

0.00

0.00

160

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/28d)

Dart Ae	rospace Lt	d						
W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
Part No		PAR #:						
	Reso	lution:	Dispositio	n:	_ QA: N/C CI	osed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCF	?)		V
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Description	ion B	Verification	Approval	Approva
		GedionA	Chief Eng	Chief Eng	Date		Chief Eng	QC Inspect
NOTE: D	ate & initial all	entries						

[,] H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

· Picklist Print

Tuesday, June 15, 2010 8:33:34 AM

Work Order ID: 59855

Parent Item:

D3909-5

Parent Item Name:

Eyebolt Stud



Start Date: 6/15/2010

Required Date: 6/21/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

as per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	_	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000		Purchased	No			100	f	24.6100	0.25	1.578947			· Mar (02)

303 Round Bar 1.00

Location	Loc Oty	Loc Code
MAT028	24.61	
113325	24.61	

7.5 JL 10/06/27

Dart Ae	rospace Ltd	t l		•				
W/O:			WO	RK ORDER CHANGES				
DATE	STEP	PR	OCEDURE CHAP	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
						4		
• • • • • • • • • • • • • • • • • • • •								

Part No):	PAR #:	Fault Categ	jory: N	CR: Yes	No DQA :	Date: _	
	Resol	ution:	Disposition	:Q	A: N/C CIG	osed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMANC	E (NCR)		
5.475		Description of NC		Corrective Action Section B		Verification		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approva QC Inspect
1								1

NOTE: Date & initial all entries

[,] H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	59855
Description: Eyebolt Stud	Part Number:	D3909-5
Inspection Dwg: D3909 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	loierance	Dimension	Accept	Reject	Inspection	Comments
Ø0.129	+0.005/-0.001	. 129				
1.38	+/-0.030	138				
0.400	+0.000/-0.010	.396				
0.700	+0.010/-0.000	-700				
R0.030	+/-0.010	, 030				
Ø0.375	+0.000/-0.020	.371				
Ø0.700	+0.000/-0.010	-695				
0.250	+/-0.010	245				
1.30	+/-0.030	1,299				
R0.06	+/-0.030	-06				
2.68	+/-0.030	2.679	1//			
0.310	+/-0.010	310				
0.750	+/-0.010	.750				
0.375 Pitch	+/-0.010	-375				
Ø1.00	+/-0.030	1.00				
0.75	+/-0.030	.752				
0.735	+0.010/-0.000	742				
	_					
						
		-				

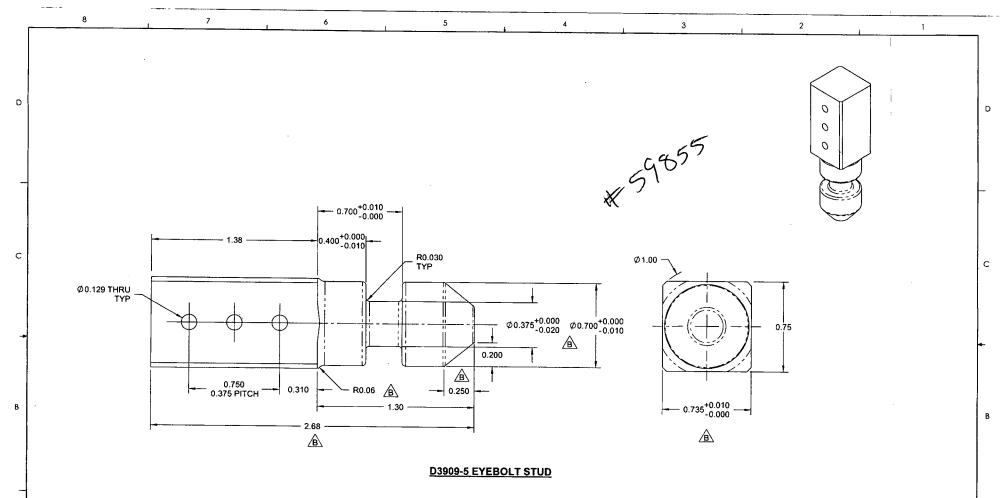
Measured by:	31,	Audited by:	81	Preliminary Appr	oval:	
Date:	10/06/27	Date:	10/06/28		Date:	
Rev Date	Change			Revised b	V Approv	/ed

	Rev	Date	Change	Revised by	Approved
7.1	Α	10.04.20	New issue	KJ 🙀	<i>N</i>

Dart Aerospace	e Ltd
----------------	-------

W/O:			V	VORK ORDER CHA	NGES						
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Q	У	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-				40.4				-			
Part No		PAR #:	Fault Ca	tegory:	NCR	: Yes N	lo DQA:			_ Date:	
	R	esolution:	Disposit	ion:	QA:	N/C Clo	sed:		<u> </u>	Date:	
NCR:		W	WORK ORDER NON-CONFORMAL				-				· · · ·
DATE	STEP	Description of NC	lm idial		Section B	Cian 0	Verifica	tid	n	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	on	Sign & Date	Section	С	_	Chief Eng	QC Inspector
								١			
								ı			
								ŀ			İ
								_	+	***	
							1	I	- 1	į	

NOTE: Date & initial all entries



NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
PER DART SPEC M303R OR M304R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.31 lbs B 7) WEIGHT: 0.31 lbs

DESIGN	JPH	DART AEROSPACE LTD					
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA					
CHECKED	WA	DRAWING NO. R	EV. B				
MFG. APPR.	1	D3909 SHEET	5 OF 5				
APPROVED	JAW 3	TITLE	SCALE				
DE APPR.	A	FWD X-TUBE LUG ASSY	NTS				
DATE 10.0	4.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THE DOCUMENT IS PROVIDE AND COMPRIBETION, AND IS EMPILIZED ON THE EXPRESS CONCITION THAT IT IS NOT TO BE USED FOR MAY PURPOSE OR CORPUS OR COMMANDATION TO BE USED FOR MAY PURPOSE OR COMMANDATION TO BE USED FOR MAY PURPOSE OR COMMANDATION FOR THE TO ANY OTHER PERSON MITHOUST MINISTRA PERSONS THE TIME AND THE TAPPOSPACE (TD)					

8

5

Dart Ae	rospace	e Ltd									
W/O:				WC	RK ORDER CH	ANGES					
DATE STEP			PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
		7	PAR #:	Fault Cate	NC	R: Yes	No DQ	OQA: Date:			
		n:	Disposition	QA: N/C Closed:				Date:			
NCR:			1	WORK ORD	R NON-CONFO	DRMANC	E (NCR)			
DATE	STEP		Description of NC Section A	Initial Chief Eng	Corrective Action Action Descri	Section B	Sign &	Verific Section		Approval Chief Eng	Approva QC Inspect
				Officer Eng	Cillel Elig		Date				
						,					:
			·				10-10-10-10-10-10-10-10-10-10-10-10-10-1				

^{*} NOTE: Date & initial all entries